

Date: 6/23/2006 7:31AM
User: Kim Johnston

PROCESS SHEET

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HIGH GEAR SKIDTUBE ASSEMBLY 2
Job No.	27663A	Part No.	D206642241
Estimate No.	10163	Drawing No.	D2650 REV E
P.O. No.	N/A	Drawing Rev.	E
First Issue	N/A	Project No.	N/A
Prsht Rev.	NC	Material	N/A
This Issue	6/23/2006	Due Date	7/20/2006
Prev. Run	27552A	QTY:	1
	Type : LANDING GEAR		

Written by:

Checked & Approved by:

Comment :

Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

Job Number:



Seq. No	Machine or Operation	Description
1.0	DC	DOCUMENT CONTROL
		<p>Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-241 CHG003</p>
2.0	D2620	Bent 206 Skidtube
		<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 Bent Tube 3" OD B27831 DP 6-7-10</p>
3.0	D32861	Doubler
		<p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler B22594 DP 6-7-15</p>
4.0	D2647	Cap
		<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap B24842 RE 6-7-10</p>
5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Seq. No.	Machine or Operation	Description
	Comment:	LANDING GEAR RESOURCE 1 1-Debur Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod <i>m100660/m18839</i> 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg 2650 from front of tube and Debur 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167. 9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove and Debur D3286-1 doubler 13-Remove 3/16" cleco's only and open GHW holes to $\varnothing 0.500$ " as per Dwg D2650 14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder 15-Remove indexing edge using DT8741 as per Dwg D2650 16-C'sink GHW rivet holes as per Dwg D2650
6.0	QC6	DIMENSIONAL CHECK
		<i>Pmc 06-07-190</i>
	Comment:	DIMENSIONAL CHECK
7.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment:	LANDING GEAR RESOURCE 1 1-Open crossbolt holes to $\varnothing 0.3125$ " as per Dwg D2650 2-Drill pilot holes using DT8028-3, then open to $\varnothing 0.297$ " as per Dwg D2650. Open Aft cap hole #6. 3-Debur tube and blow out chips from inside the tube
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>Pmc 0607-200</i>
	Comment:	HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>DP 6-7-20 1</i>
	Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION

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Seq. No.	Machine or Operation	Description
10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
12.0	CR3212404	Cherry Rivet
	Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s) Pick: Qty Part Number Description Batch 52 CR3212-4-04 Rivet M19185/M101415	
13.0	D26543	206 I-Beam (Web)
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2654-3 Web B27964	
14.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting Start Date: 06-07-21 Time: 7:15 Finish Date: 06-07-24 Time: 1:00 Pick: Qty Part Number Description Batch A/R Sikaflex-291 M101193 Sikaflex expire date: 06-01-01	
15.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
16.0	D2649	Crossbolt Spacer
	Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s) Pick: Qty Part Number Description Batch 18 D2649 Crossbolt spacer B25864	

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Seq. No.	Machine or Operation	Description
17.0	D32863	Spacer
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-3 Spacer <i>B24711 BE 06-08-10</i>		
18.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
 		
Comment: LANDING GEAR RESOURCE 1 1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod <i>M18839 BE 06-07-24 ①</i> 2-Grind welds flush as per Dwg D2650. <i>BE 06-08-04 ①</i> 3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.402" before welding other side. Use SS rod as required. A/R SS Rod <i>NONE BE 06-08-10 ①</i> 4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Debur <i>BE 06-08-10 ①</i>		
19.0	CCR264SS33	Cherry Rivet
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 CCR264SS3-3 Rivets <i>M119099 DP 6-8-11</i> <i>M18548 Rivet</i>		
20.0	M7885343	Rivet
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 M7885/3-4-3 Rivets <i>M18548 DP 6-8-11</i> <i>M19099</i>		
21.0	D2680041	Nut Plate
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2680-041 Nut Plate <i>B24203 DP 6-8-11</i>		
22.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
 		
Comment: HAND FINISHING RESOURCE #1 Install D2680-041 Nut Plate as per Dwg D2650 <i>DP 6-8-11</i>		
23.0	QC5/9	WELD INSPECTION
 		

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	Comment:	Inspect weld and Counterbore work to Current Step . Inspect for foreign objects as per QSI 024
24.0	POWDER COATING	POWDER COATING
	Comment:	POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. <i>TC 060821</i>
25.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>a.m 06-08-21</i> ①
26.0	D26483	Wearpad
	Comment:	Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2648-3 Wearpad <i>B27169-2</i>
27.0	D265613	Wearplate.
	Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2656-13 Wearshoe <i>B27049</i>
28.0	D265621	Wearplate
	Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2656-21 Wearshoe <i>B20917</i>
29.0	D265633	Wearplate
	Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2656-33 Wearshoe <i>B20213</i>
30.0	D34291	
	Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3429-1 Wearpad <i>B24407</i> <i>a.m 06-08-21</i> ①
31.0	ALS41032130	Insert

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Seq. No.	Machine or Operation	Description
	Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s) Pick: Qty Part Number Description Batch 44 ALS4-1032-130 Inserts <u>m 19393</u> or (see QSI 017)	
32.0	AN960JD10L	Washer
	Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s) Pick: Qty Part Number Description Batch 44 AN960JD10L Washer <u>m 100233</u>	
33.0	MS27039108	Screw
	Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s) Pick: Qty Part Number Description Batch 44 MS27039-1-08 Screw <u>m 19551</u> L	
34.0	D26511	Plug
	Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s) Pick: Qty Part Number Description Batch 18 D2651-1 Plugs <u>B 27362</u>	
35.0	D26513	O-Ring
	Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s) Pick: Qty Part Number Description Batch 18 D2651-3 O-Rings <u>B 25866</u>	
36.0	MS27039406	Screw
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 MS27039-4-06 Screw <u>m 6874</u>	
37.0	AN960JD416	Washer
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN960JD416 Washer <u>m 151</u> a.m 06-08216	
38.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

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	Comment: HAND FINISHING RESOURCE #1	
	1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 <u>m101855</u> Sikaflex expire date: <u>02-07</u>	
	2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.	
	3-Install MS27039-4-06 Screw as per DEO 9153.	
39.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect for foreign objects as per QSI 024	<u>m 06-08-21</u> ①
40.0	D2646	Aft Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2646 Aft Cap <u>B 22567</u>	<u>L</u>
41.0	MS27039108	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 MS27039-1-08 Screw <u>m 19551</u>	<u>L</u>
42.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 AN960JD10L Washer <u>m 9455</u> <u>18235</u>	<u>a.m 06-08-21</u> ①
43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>m101855</u> Sikaflex expire date: <u>02-07</u>	<u>a.m 06-08-21</u> ①
	2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4 Batch: <u>m101662</u>	
44.0	QC3/5	INSPECT WORK/WING WALK
	Comment: INSPECT WORK/WING WALK	<u>Joe-08-22</u> ①

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/08/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
45.0	DC	DOCUMENT CONTROL
		
Comment: DOCUMENT CONTROL Inspection Level 21		

S 06/08/08 1

Job Completion



u 06.08.08

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>147</i>	DRAWN BY <i>147</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED

16 04 17 *PH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET


NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

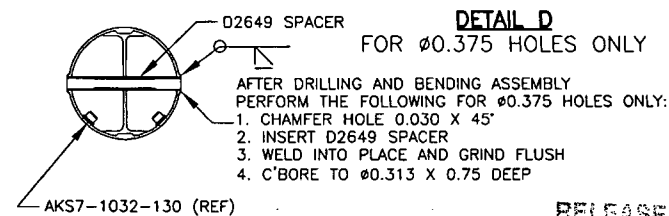
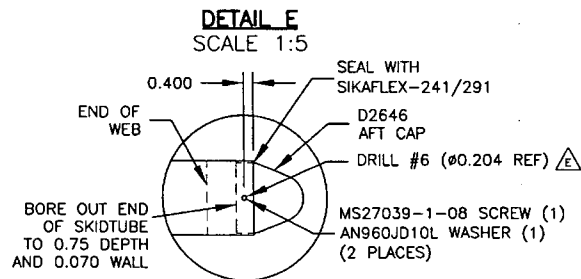
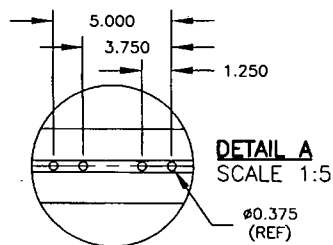
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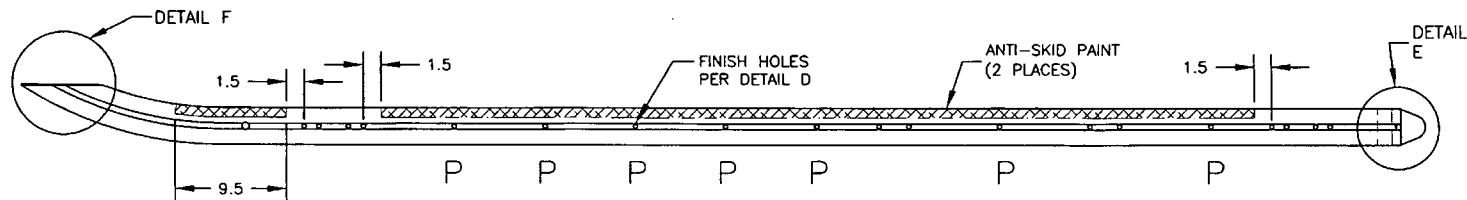
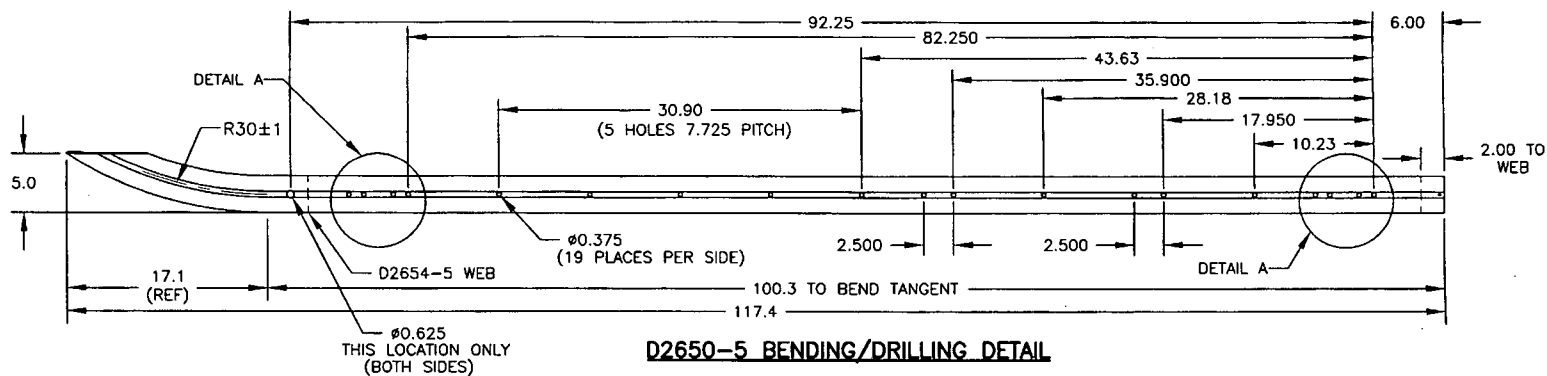
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	CHECKED <i>P4</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 2 OF 5
	DATE 06.03.30	TITLE SKIDTUBE SCALE 1:10		

1:1



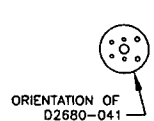
RELEASED



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



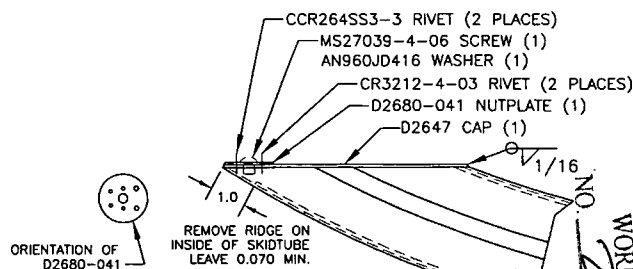
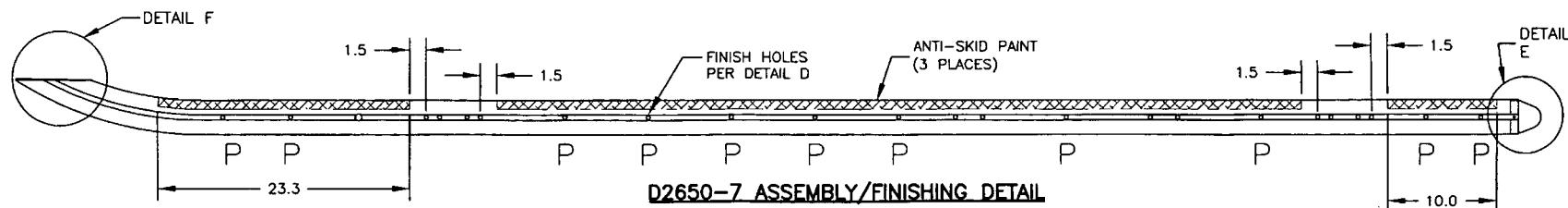
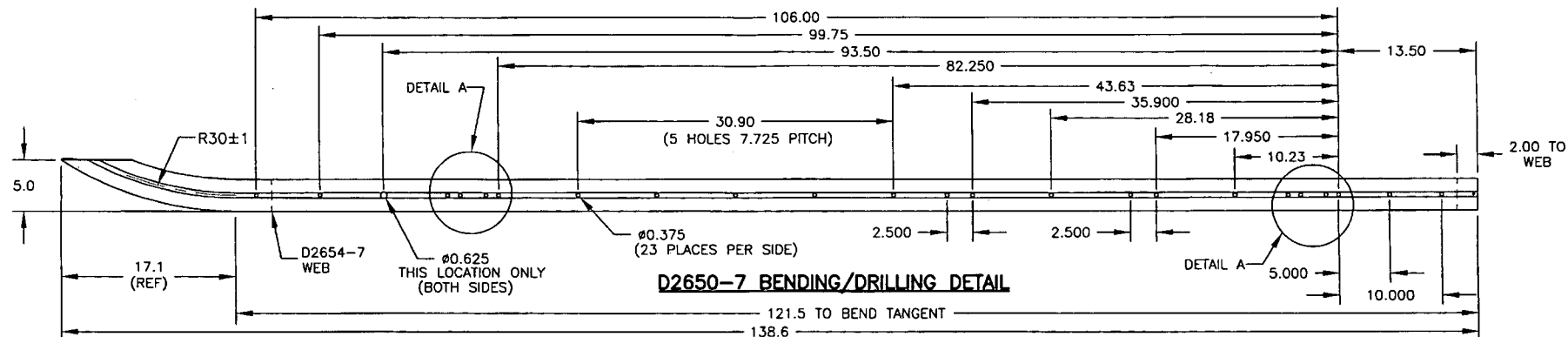
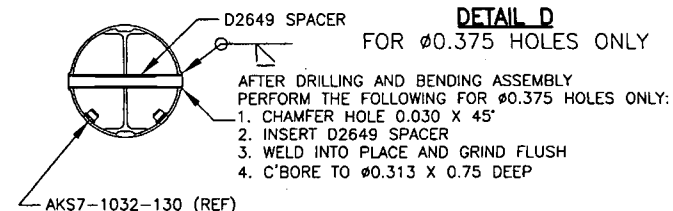
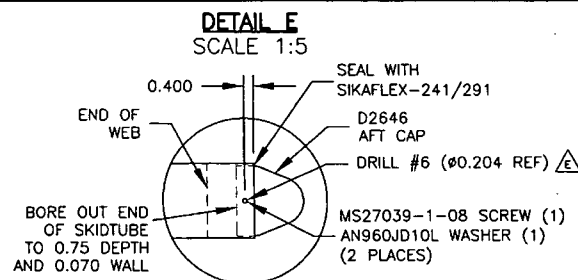
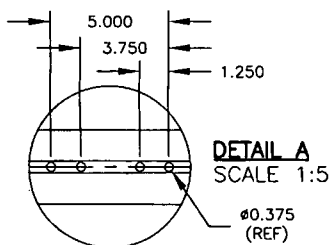
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

- CCR264SS3-3 RIVET (2 PLACES)
- MS27039-4-06 SCREW (1)
- AN960JD416 WASHER (1)
- CR3212-4-03 RIVET (2 PLACES)
- D2680-041 NUTPLATE (1)
- D2647 CAP (1)

NO. 27163A

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		DATE	06.03.30	TITLE	SKIDTUBE	REV. E SHEET 4 OF 5 SCALE 1:10



- DETAIL F (NOT TO SCALE)**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO INSTALLATION

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